

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004104**Date Inspected:** 02-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Kuan Chung**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower,Jacking and Deviation Saddle**Summary of Items Observed:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and repair of Saddles.

**FBARICATION SHOP # 4**

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at JSW fabrication shop number 4 and observed the in process assembly fit-up operation of the structural steel to casting of the West Deviation Saddle base W2E1.

**NDT**

The QA inspector periodically observed The Nikko Inspection Services (NIS) QC/NDT technicians Mr. Kazuya Kobayashi and Mr. Kumagai perform magnetic particle (MT) testing of West Deviation Saddle base W2E2 after PWHT and Tower Jacking Saddle T1-1. The MT was performed in accordance with ASTM standard E709, using the yoke method. The yoke utilized appeared to be model VM3. The yoke dead lift was verified with a 4.65kg test plate. The magnetic field was verified with a field indicating gauge (pie gauge) with red dry powder. All calibrations appear to meet the minimum requirements of ASTM E709. The testing was evaluated in accordance with the contract special provisions.

The testing was not completed on this date.

**NDT Inspection (Foundry Shop)**

On this date the QA representative Dong J. Shin arrived at Japan Steel Works (JSW) of Muroran Japan and traveled to JSW foundry shop, QA Inspector observed NISC NDT Technician Mr. A. Seno and Mr. H. Kohama

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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performed Ultrasonic testing on Casting T1-3. Ultrasonic testing was performed after rough machining. QA Inspector Mr. Dong j. Shin has checked Ultrasonic testing was performed by straight beam and angle beam testing and QA Inspector Mr. Dong J. Shin confirmed the calibration date of Ultrasonic testing unit, DAC curve and scanning pattern.

Results appear to meet approved test procedures and ASTM 609M.

The ultrasonic testing was not completed this date.

### Summary of Conversations:

No specific conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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